

Date: Wednesday, 4/4/2007 9:01:18 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 L/L 1/L3 SCUFF PLATE, FWD RH
Job Number	: 31605		
Estimate Number	: 12269		
P.O. Number	: <i>N/A</i>	Part Number	: D206555006
This Issue	: 4/4/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D206-555 REV C
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 30365	Drawing Revision	: C
	Type : SMALL /MED FAB	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 4/20/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	10 Um: Each
Comment	: Est C 99-96.29 Returned to Electro Polish DM Est Rev:D Now On Waterjet 07-01-22 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL
 Type Labels as per PPP D206-555-006

2.0	M304S25GA	304/316 .020" Sheet
-----	-----------	---------------------



Comment: Qty.: 0.4610 sf(s)/Unit Total : 4.6100 sf(s)
 304/316 .020" Sheet
 Batch: *103504*

ml 07 06 02

(10)

3.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D206-555
 Dwg Rev: *C*
 Prog Rev: *C*

ml 07 06 02

(10)

2-Deburr if necessary

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



ml 07 06 02



(10)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SA 07.06.07

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 9:01:19 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L/L 1/L3 SCUFF PLATE, FWD RH

Job Number: 31605

Part Number: D206555006

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form parts on hydraulic press as per Dwg. D206-555 using DT 8318-6

Finish form on bench forming Jig DT 8319-6

8 P/O

SB 07/06/06

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

207-06-07 (8)

8.0

OUTSIDE SERV.20

OUTSIDE SERVICE - SF



Comment: Sub-Contracting Outside services

Electrochemically polish per ASTM B912, High shine finish, No scratches on surfaces.

Issue P/O: 3923

Possible supplier: TQF Technologies

07/06/07 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

07/06/08 (8) (8)

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

En 07/06/20 x 8

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Remove tooling tabs and deburr

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 27/11/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>27/11/25</u>	<u>6</u>	<u>2 parts made</u> <u>25 -005</u>	<u>QSI/HR</u>	<u>create w/o for</u> <u>2x 206-555-005 - to use</u> <u>parts</u>	<u>u</u> <u>27/11/25</u>	<u>QSI/HR</u> <u>27/11/25</u>	<u>QSI/HR</u>	<u>QSI/HR</u>

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 9:01:19 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L/L 1/L3 SCUFF PLATE, FWD RH

Job Number: 31605

Part Number: D206555006

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

N/A

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

RED LABEL

(10)

07/5/24

(8)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/25

Job Completion



07.06.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN JB	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555	REV. C SHEET 1 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE NTS
A	89.06.08	NEW ISSUE	
B	98.10.26	RE-DRAWN ADDED D206-555-011/-012/-045	
C	06.09.01	REVISED FINISH PER NCR 016	

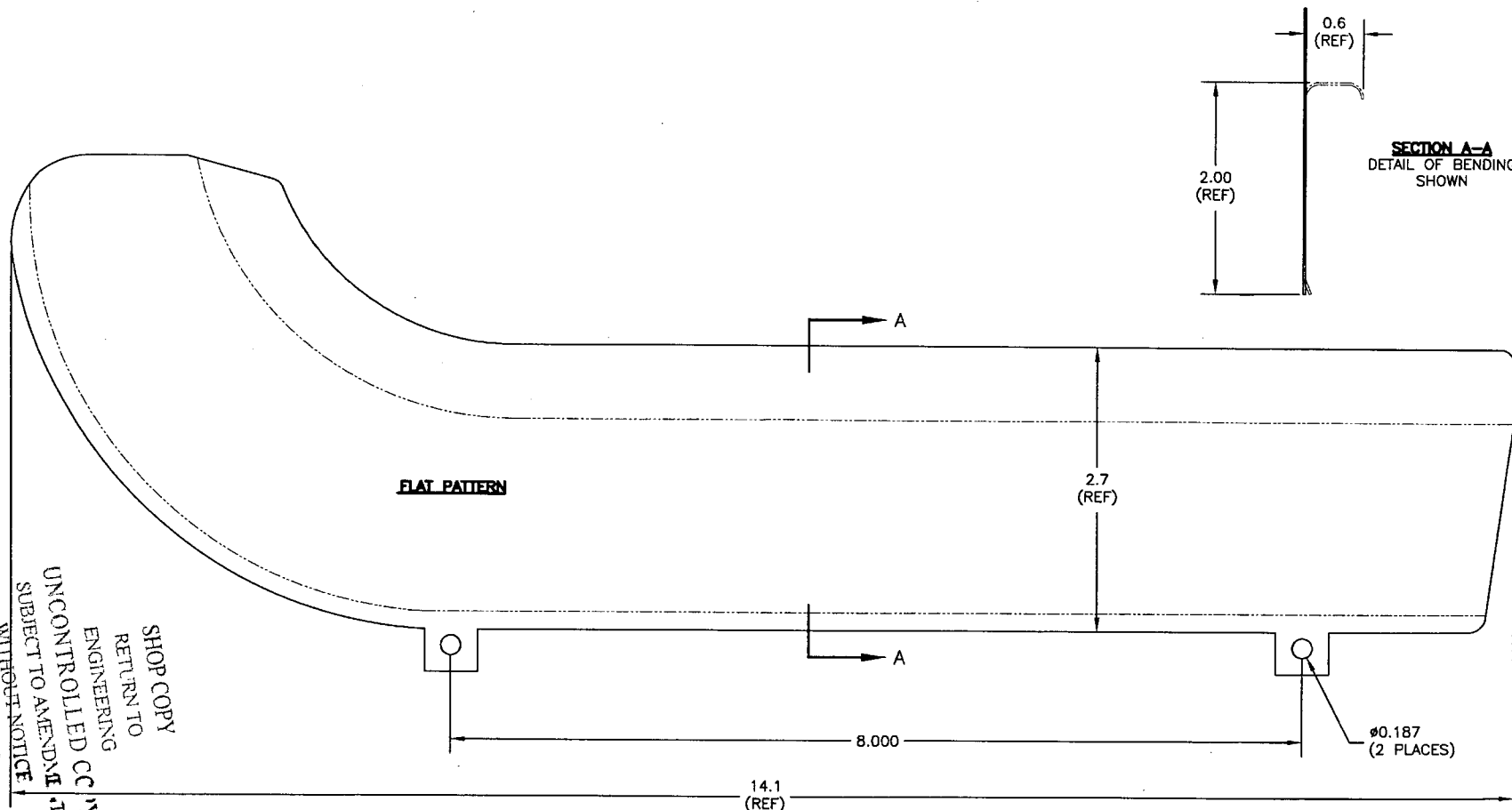
QTY REQUIRED			PART NO.	DESCRIPTION
-041	-043	-045		
X			D206-555-041	SCUFF PLATE KIT 206 A/B
	X		D206-555-043	SCUFF PLATE KIT 206 L/L1/L3
		X	D206-555-045	SCUFF PLATE KIT 206 L/L1/L3, EXECUTIVE INTERIOR
1			D206-555-001	FORWARD LH
1			D206-555-002	FORWARD RH
1			D206-555-003	AFT LH
1			D206-555-004	AFT RH
	1		D206-555-005	FORWARD LH
	1		D206-555-006	FORWARD RH
	1	1	D206-555-007	AFT LH
	1	1	D206-555-009	AFT RH
		1	D206-555-011	FORWARD LH
		1	D206-555-012	FORWARD RH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31605

RELEASED
06.09.19 *[Signature]*

Copyright © 1989 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



D206-555-001 (BEND IN DIRECTION SHOWN IN SECTION A-A)
D206-555-002 (BEND OPPOSITE)

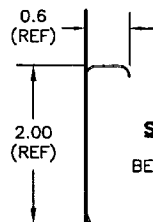
NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T1
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

06.09.19

DESIGN JB	DRAWN BY JB	DART DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED PH	DRAWING NO. D206-555	SHEET 2 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 1:1	



SECTION C-C
DETAIL OF
BENDING SHOWN

DETAIL B
SCALE 1:1

REFER TO DETAIL B
FOR 1:1 SCALE

FLAT PATTERN

8.000

19.0
(REF)

8.000

Ø0.187
(3 PLACES)

2.7
(REF)

16.000 (REF)

C

C

W31605
UNCONTROLLED COPY
ENGINEERING
SHOP COPY
SUBJECT TO
WITH

D206-555-003 (BEND IN DIRECTION SHOWN IN SECTION C-C)
D206-555-004 (BEND OPPOSITE)

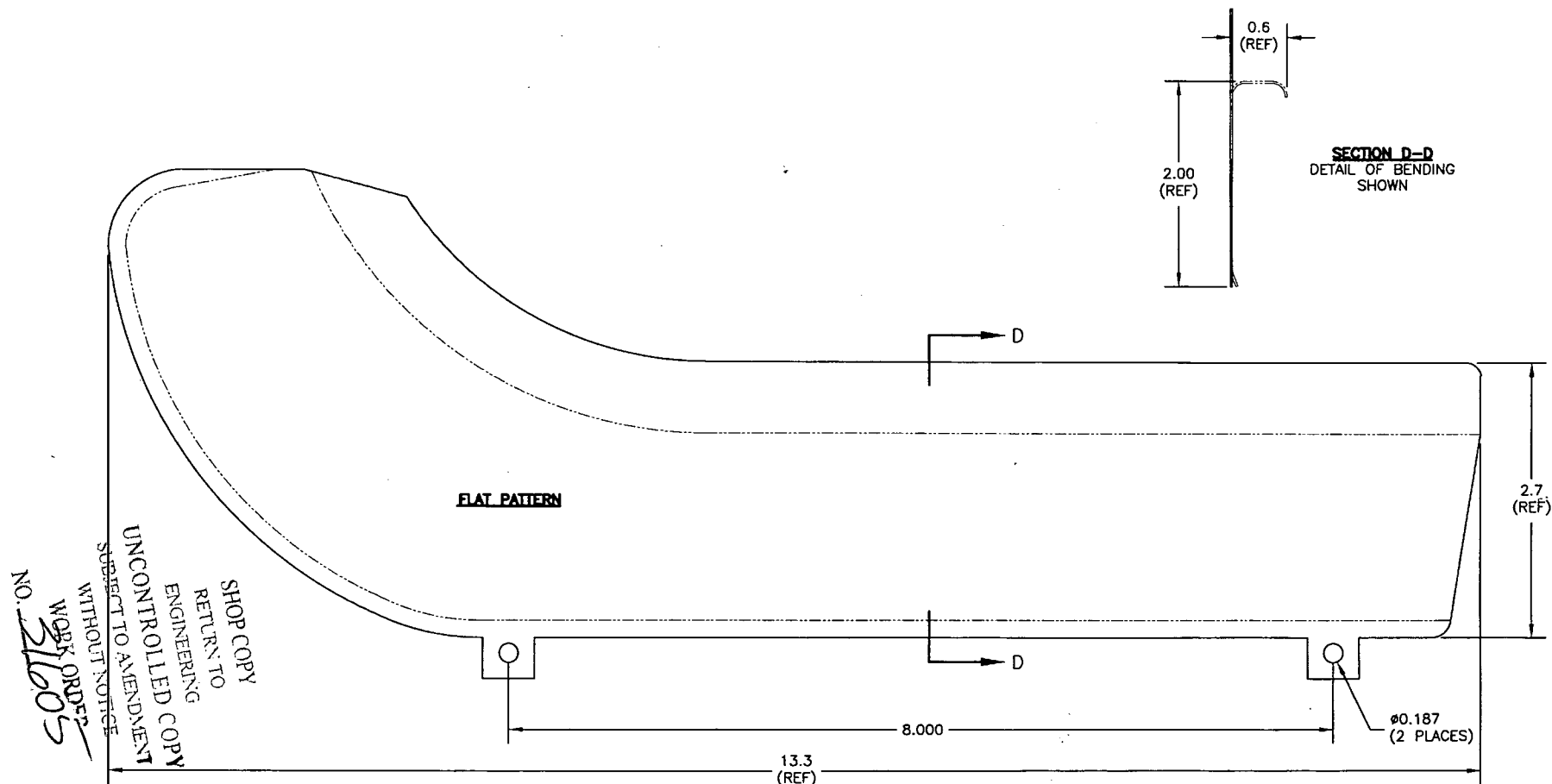
NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T3
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

06 09 19-11

DESIGN JB	DRAWN BY [Signature]	DART DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED [Signature]	DRAWING NO. D206-555	SHEET 3 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE 2:3



D206-555-005 (BEND IN DIRECTION SHOWN IN SECTION D-D)
D206-555-006 (BEND OPPOSITE)

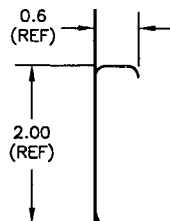
NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T5
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

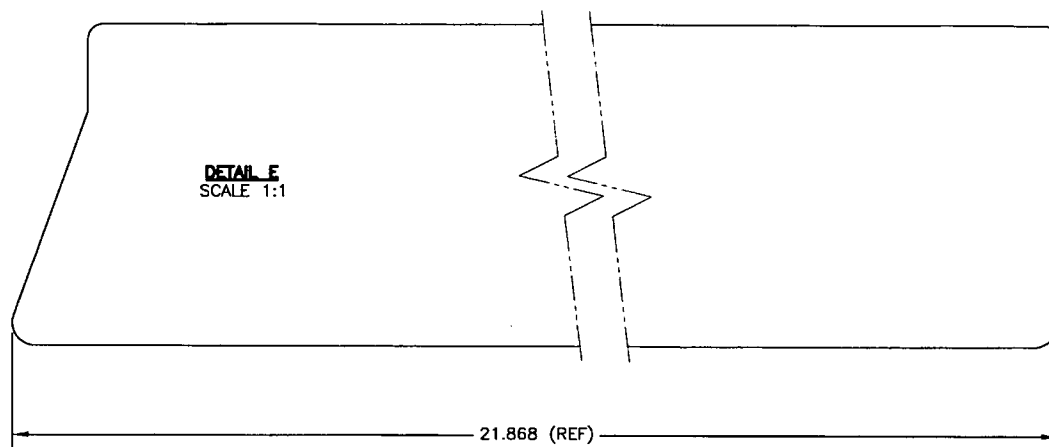
RELEASED

06-09-19

DESIGN JB	DRAWN BY JB	DART DART AEROSPACE LTD MILWAUKEE, WISCONSIN, U.S.A.	REV. C
CHECKED PH	APPROVED PH	DRAWING NO. D206-555	SHEET 4 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 1:1	

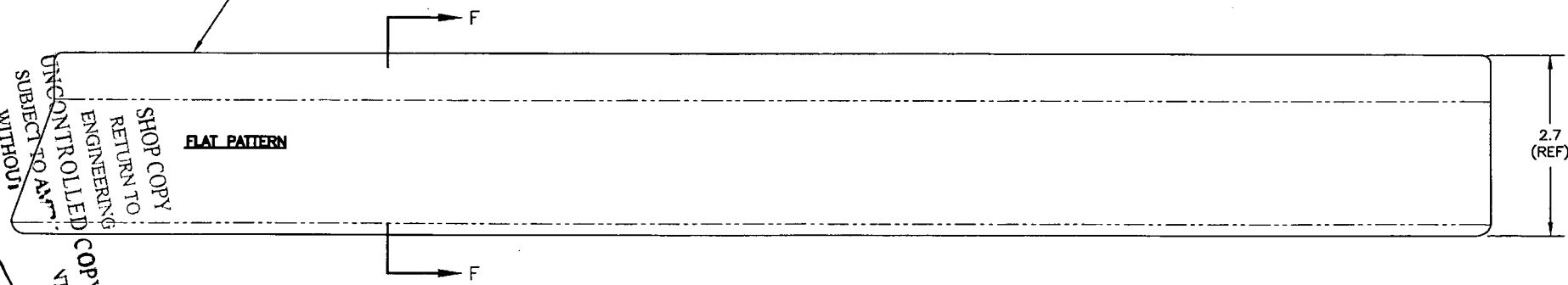


SECTION F-F
DETAIL OF
BENDING SHOWN



REFER TO DETAIL E
FOR 1:1 SCALE

21.868 (REF)



2.7
(REF)

D206-555-007 (BEND IN DIRECTION SHOWN IN SECTION F-F)

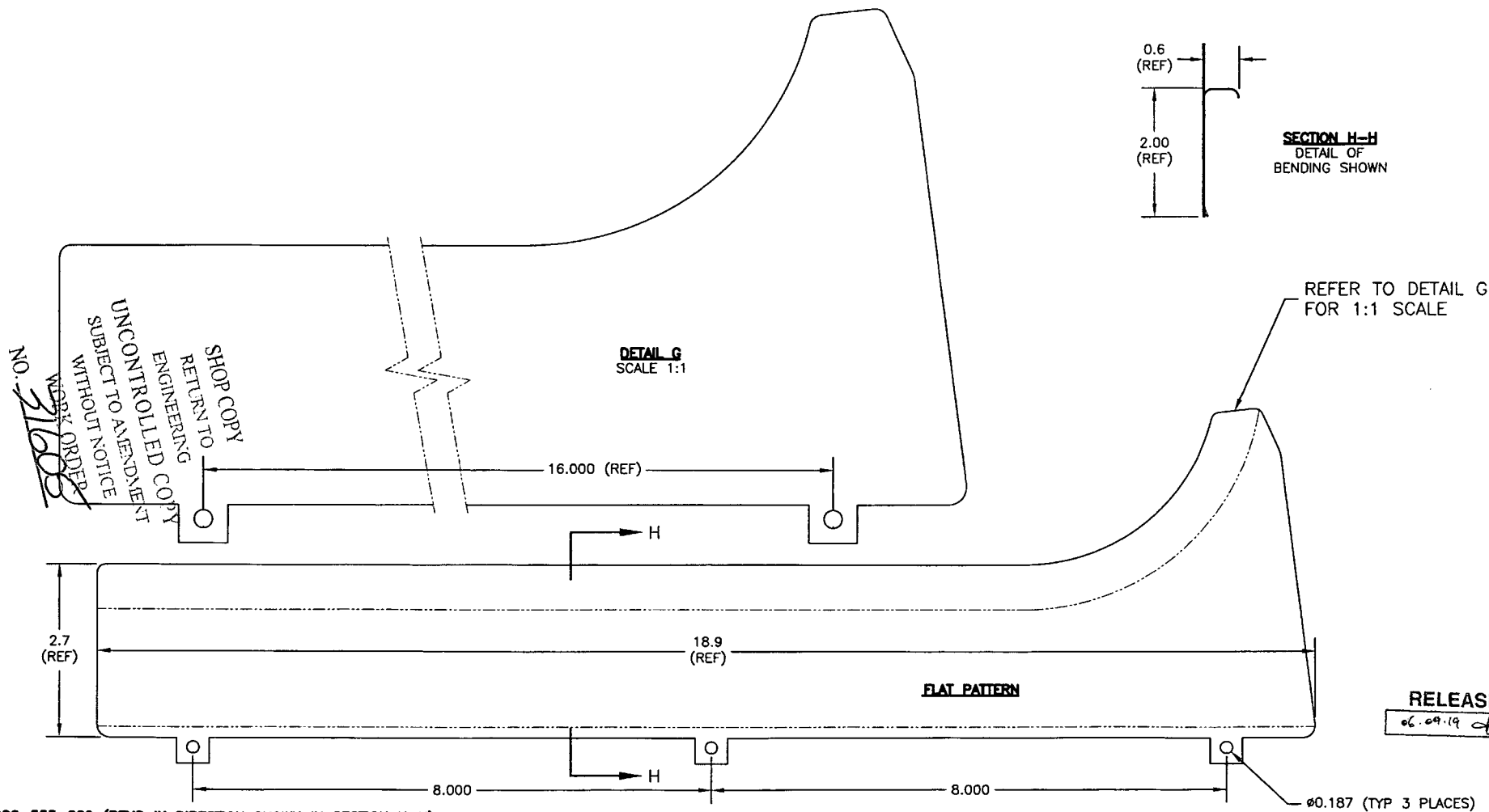
NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T7
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

06.09.19 #

DESIGN	DRAWN BY	DART DART AEROSPACE LTD WILKESBARR, ONTARIO, CANADA	
JB	JB	DRAWING NO.	REV. C
CHECKED	APPROVED	D206-555	SHEET 5 OF 7
PH	#	TITLE	SCALE
DATE		DOOR SILL SCUFF PLATES	2:3
06.09.01			

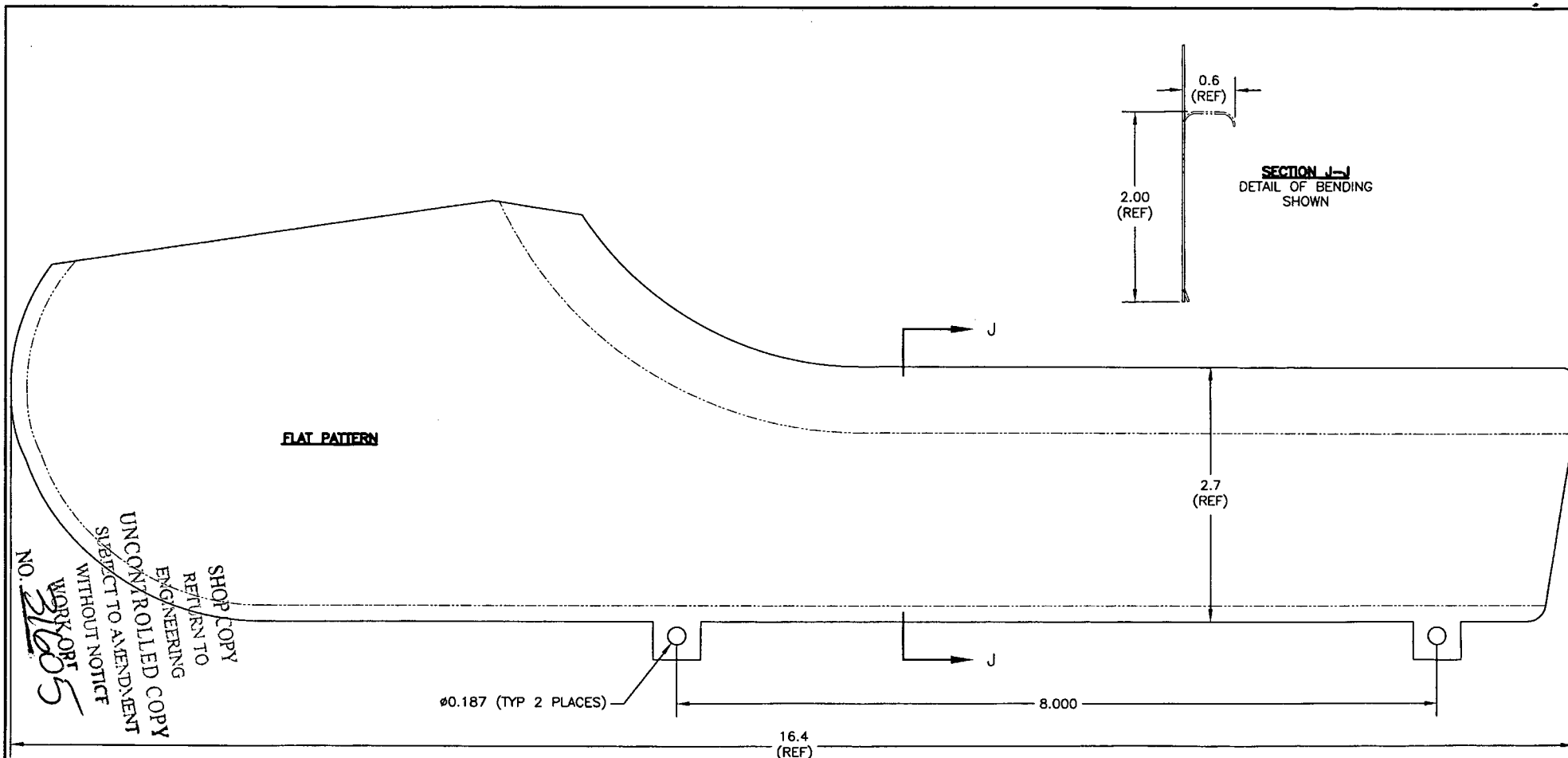


D206-555-009 (BEND IN DIRECTION SHOWN IN SECTION H-H)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T9
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY JB	DART DART AEROSPACE LTD HAMMERSLEY, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED PH	DRAWING NO. D206-555	SHEET 6 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 2:3	



D206-555-011 (BEND IN DIRECTION SHOWN IN SECTION J-J)
D206-555-012 (BEND OPPOSITE)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T11
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

06.09.19


DESIGN JB	DRAWN BY JB	DART DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED [Signature]		SHEET 7 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 1:1	

DART AEROSPACE LTD		Work Order: 31605
Description: 206 L/L1/L3 Scuff Plate, FWD RH		Part Number: D206-SS5-006
Inspection Dwg: D206-SS5 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 13.3	+/-0.100	13.3	✓		Measuring tape	
B 8.000	+/-0.010	8.000	✓		Measuring tape	
C 2.7	+/-0.100	2.702	✓		Vern	
D ϕ 0.187	+0.005-0.001	0.189	✓		Vern	
E						
F						
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: ml ml	Audited by: 	Prototype Approval:	N/A
Date: 07 06 02	Date: 07 06 04	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	



Certificat de Conformité / Certificate of Compliance

A/TO: Dart Aerospace Ltd.

Date: June 15, 2007

1270 Aberdeen St

No. de certificat
Certification No.

Hawkesbury, Ontario

K6A 1K7

tel.: (613) 632-5200

fax: (613) 632-1053

C117012

bon de T. Job No.	Qt	# de pièce / Part #	Remarques / Remarks
127963		NO. DE COM./P.O.# 3923	ELECTROPOLISH PER ASTM B912 REV.02
	8	D206-555-006 B31605	
	2	D206-555-005 B32753	

Nous certifions que les parties listées ci-dessus ont été faites et inspectées en conformité avec votre bon de commande, vos dessins et specifications et sont en accord avec les exigences ci-inclus.

We hereby certify that the parts listed above have been processed and inspected in accordance with your purchase order, drawings and specifications, and are correct with regard to the requirements contained therein.

Signé pour et au nom de TQF Technologies Inc.
Signed for and on behalf of TQF Technologies Inc.

G. Persaud / G. McPhee

DART Aerospace Ltd

CUSTOMER RETURN

#R08-019

Initiator: Jan Kerr
Company: TAIGA Air Services
CTAIGOI
Phone No: 204-943-3645
Reason for return: Plates do not fit.

Date: March 6/06
Invoice # 5053
Order Entry # 4953

Attach Copy of DHS Return Authorization # 376

Receiving: PC
Date Received: 8/3/19 Freight Company: Frederick Prepaid Collect

#	Part #	Batch #	Description	Distribute to QC	
				Advise QA	Date:
1	D206-555-006	31605	Scuff plate RH	<u>DATE</u>	<u>8/3/19</u>
1	D206-555-005	31184	Scuff plate LH		

Condition of packaging: Good Photograph required: yes noPaperwork attached: P/S X Invoice _____ ARC _____ Docs _____ Other _____

QC:

Quarantine: _____ Location: _____ Condition of Part: goodInspect: _____ Initial: J

#	Part #	Batch #	QC Comments	QC Approval		Scrap
				Initial	W/O #	
1	D206-555-006	31605	Quarantine per W/O - UCR	<u>[Signature]</u>	38117	
1	D206-555-005	31184			38118	

QA Coordinator:

Advise GM as to findings: _____ Initial: _____ Date: _____

Comments: _____

_____Issue credit: yes no

GM Approval: _____ Date: _____

Invoice Amount: _____
Less Replacement: _____
Restock Fee: _____
Freight: _____
Net Credit: _____
DHS ☐ Customer ☐

QA: Enter into Q-Pulse with reason for return & File original. Signed: _____ Date: _____

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit